

Date: Tuesday, 08/04/2008 4:52:45 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET BASE ASSEMBLY (350)		
Job Number	: 38457C			<i>4/04/09</i>		
Estimate Number	: 10189					
P.O. Number	:			Part Number	: D2221	
This Issue	: 08/04/2008		S.O. No. :	Drawing Number	: D2221 UFR, D2235	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: F/B1	
Previous Run	: 38456C			Material	:	
Written By	:			Due Date	: 30/04/2008	
Checked & Approved By	<u>JD 08.4.09</u>			Qty:	1 Um: Each	
Comment	: Est Rev.J 05.09.02 Added D3442-1KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31661	Basket Hoop	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick: ✓	
		Qty Part Number Description Batch	
		4 D3166-1 RIB <u>337611</u>	<i>PL 08.04.28</i>
2.0	D22323	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: ✓	
		Qty Part Number Description Batch	
		2 D2232-3 Hinge bracket <u>336846</u>	<i>PL 08.04.30</i>
3.0	D2325	Support Gusset (350 Bask)	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick: ✓	
		Qty Part Number Description Batch	
		4 D2325 Support Gusset <u>336691</u>	<i>PL 08.04.28</i>
4.0	D23273	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: ✓	
		Qty Part Number Description Batch	
		2 D2327-3 Bushing <u>M37851</u>	<i>PL 08.04.28</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET BASE ASSEMBLY (350)

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Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket 137248



FC 08 04 30

6.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim 137615



FC 08 04 30

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)

Pick:

Qty Part Number Description Batch

39.69 sf M304EX0.75-16F Expanded Metal M 107316



FC 08 04 30

8.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick: 0.065 10 03.04.09

28" 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: 107515



SAB 08/04/27

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

FC 08-04-28

2-Drill hole in D2221-3 as per Dwg D2221

FC

3-Deburr

Sab 08/04/27

①

4-Remove all markings on material before welding

FC

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

FC 08 04 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 38457C

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/05/01

11.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

B 38457C
D 02221
01/05/2008

12.0 POWDER COATING POWDER COATING



1107550

S.177 15.49
#1 403.9 F
#2 30 ---- F
#3 30 ---- F
#4 100 F

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

13.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. 08/05/01

14.0 QC21 FINAL INSPECTION/W/O RELEASE



08/05/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

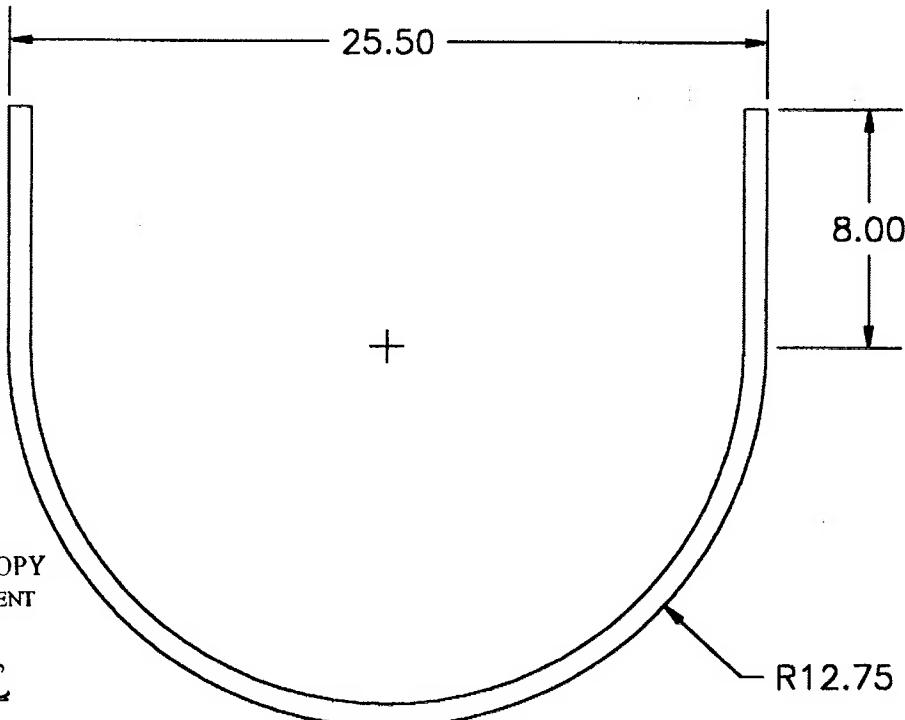
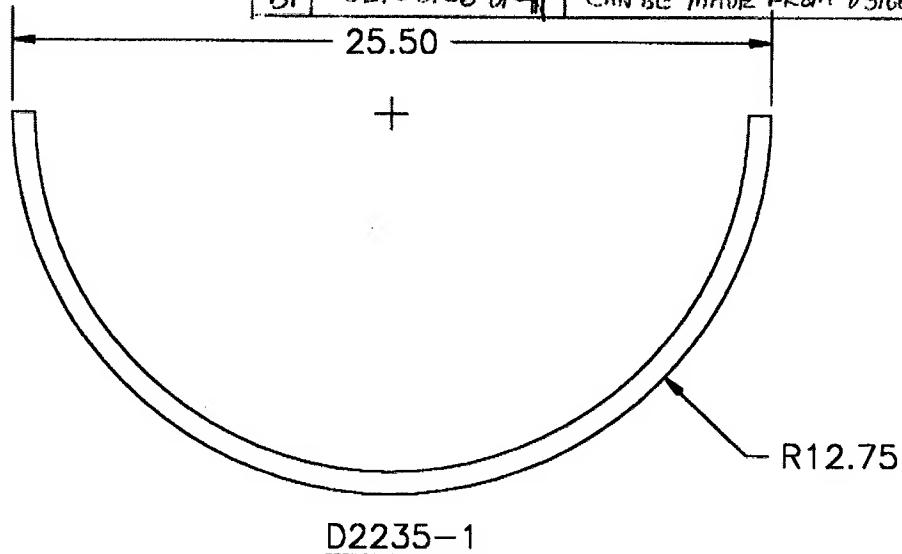
NOTE: Date & initial all entries

DART

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235
DATE 94:12:16		TITLE BASKET RIBS

REV. B
SHEET 1 OF 1

BI 02.08.06 (P-1) CAN BE MADE FROM D3166-1

RELEASED
R 960507

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38451C

CAN BE MADE FROM D3166-1 BI
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.



DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>H</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS

RELEASED

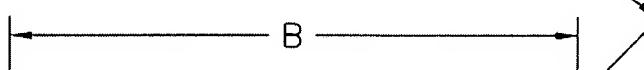
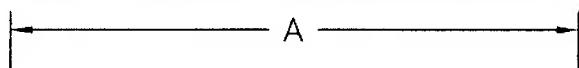
05.08.19 *H*

C	95.11.21	SEPARATE BASKET AND LID
D	96.06.21	CHANGE LATCH
E	01.04.19	CHANGE HINGE
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM

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WITHOUT NOTICE
WORK ORDER
NO. *3845TC*



UNDER REVIEW

08-04-04 AD

TUBING CHANGED TO 3/4 INCHES

WHY

08-04-09

D2221-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING (REF. DART SPEC M304TS0.750W.060) *0.065 AD 08.04.09*
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL ϕ 0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID

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5 Ø0.257 (TYP 5 PLACES)
(DRILL WHEN ASSEMBLING WITH
D2989-041/-043 LID ONLY)

5 Ø0.257 (TYP 5 PLACES)
DRILL WHEN ASSEMBLING WITH
D2989-041/-043 LID ONLY)

6.50
(TYP BOTH ENDS)

D2221-5 (2) —

D2221-3 (2)

2325 (REF)

ENGINEERING
CONTROLLED (C)
CONNECT TO AMENDMENT
WITHOUT NOTICE

21 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS. (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY, WHITE (4.3.5.2) PER DART QSI 005 4.3

UNDER REVIEW
10/15/85 AM

~~08.02.05 AM~~
TUBING TO BE
CHANGED TO 0.055
WALL 08.04.09
~~AM~~

D2232-3

D3442-1

DETAIL D
(SCALE 1:1)
(TYP BOTH ENDS)

M304EX0.75-16F

OTED

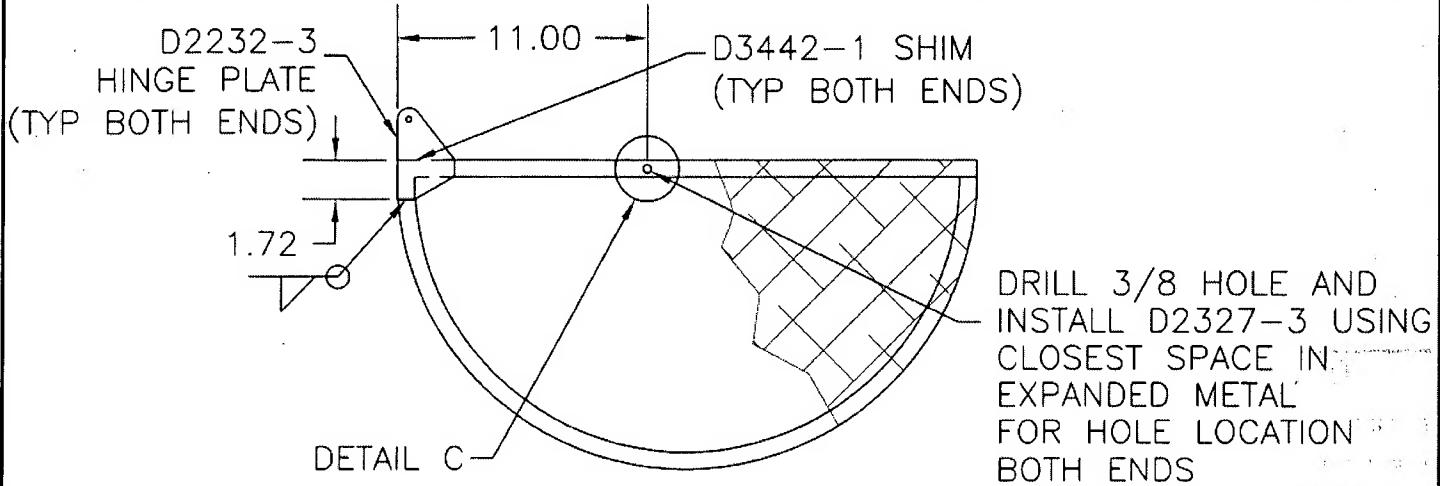
DETAIL D
(SCALE 1:1)
(TYP BOTH ENDS)



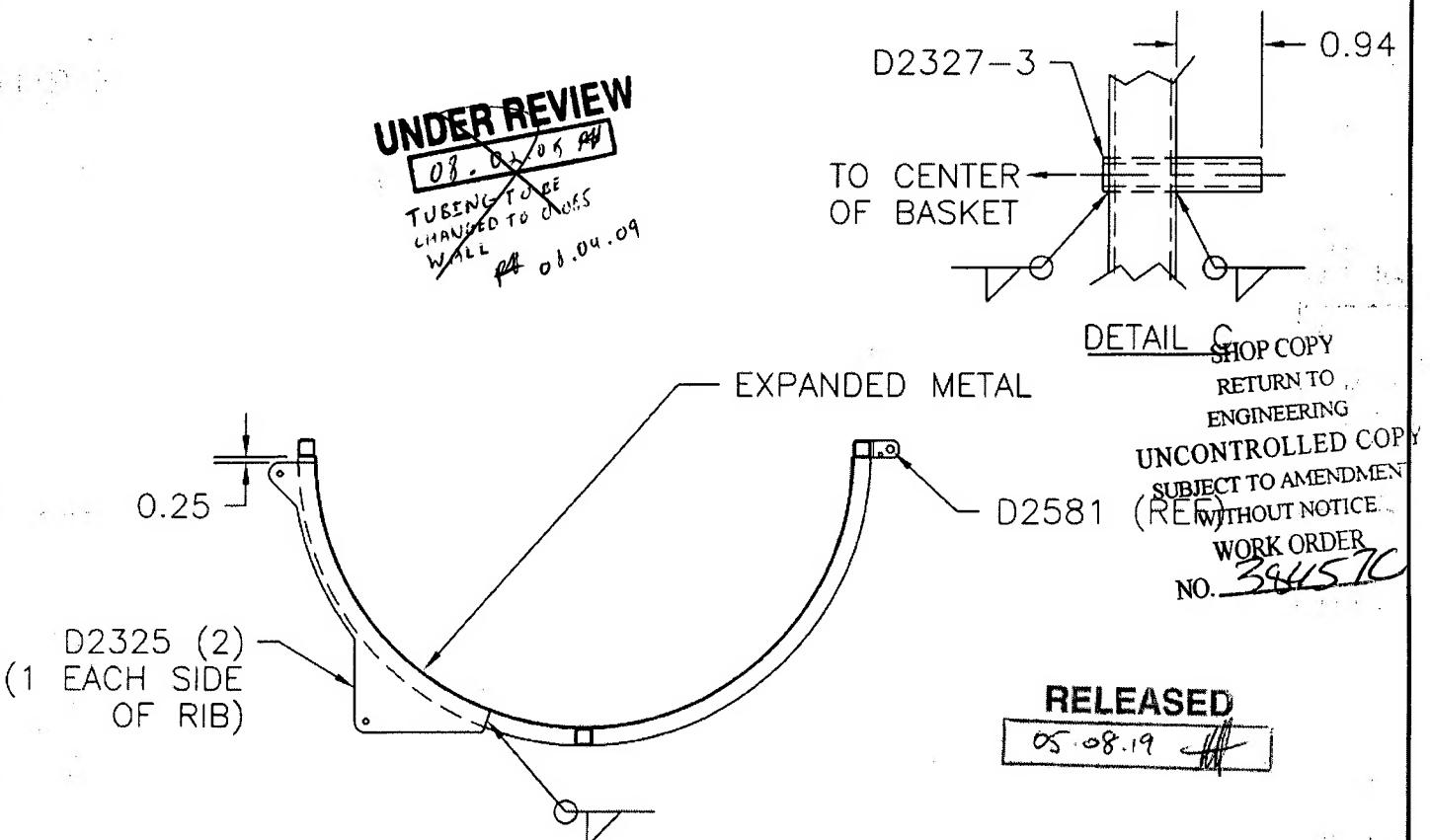
		DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
DESIGN	BW	DRAWN BY	REV. F
CHECKED	PH	APPROVED	SHEET 2 OF 3
DATE	TITLE	SCALE	
05.06.07	BASKET BASE ASSEMBLY (350)	1:20	



DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8



SECTION A-A SAME BOTH END RIBS



SECTION B-B SAME BOTH CENTER RIBS

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